



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.9810

Job Sheet 165122



Part No: 646.9810

Job Qty: 22 ea

Part Name: Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A SHEETS 1,2,3 IPP REV:A NEW ISSUE 13/04/01 JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	22 Ea	10/26/17	0.00	0.00	Start up container	
110	CNC Vertical Machining	22 pcs	10/31/17	0.49	52.38	HAAS 1	
120	QC	22 pcs	10/31/17	0.00	0.00	QC2	
130	QC	22 pcs	10/31/17	0.00	0.00	QC8	
140	Outsource	22 pcs	10/31/17	0.00	0.00	Outsource4	
150	Packaging	22 pcs	10/31/17	0.00	0.00	Packaging2	
155	QC	22 pcs	10/31/17	0.00	0.00	QC5	
180	Packaging	22 pcs	10/31/17	0.00	0.00	Packaging3	
190	QC21-SA	22 Ea	10/31/17	0.00	0.00	QC21	

Part Op 110 - Billet size: 1.250" X 7.000" X 50.000" 1-Machine per folio FB162

Descriptions: 140 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 646.9800

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

21
9-89

MAY 22 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	646.9810 B165122	484	22	0	0

Part Specifications

Specifications could not be found.

Plex 10/3/17 9:56 AM dart.poulin.mario

Status: Stock

Part: **646.9810 B165122**

Created: 9/30/17 10:39 AM DART.MICHAUD-
FEBRILLE.VICTORIA



Serial No: **S000006**

Printed By: Goldston, Justin 10/2/17 10:44 AM

Work Order Summary

Thursday, September 28, 2017 10:47:12 AM

Page 1 of 2

Criteria : Work Order ID: 165122 Item ID: 646.9810 Product Family MACHINING
Work Order Start Dates 8/25/2017 to 8/25/2017 11:59:59 PM Work Order Required Dates 9/8/2017 to 9/8/2017 11:59:59 PM
All References
Work Order Status Released

Work Order ID	165122	Required Qty	22.0000	Status Code	Released
Item ID	646.9810	Accepted Qty	4.0000	Scrap Qty	0.0000
Item Name	Deflector				
Current Acct Value	\$535.725				
Start Date	8/25/2017	Required Date	9/8/2017	Completed Date	
Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **	
Direct Costs	Total	Each	Each	Each	Each
Material	\$868.035	\$217.009	\$217.243	\$0.235	0.11%
Labor	\$1,201.852	\$300.463	\$76.860	(\$223.603)	-290.92%
Outplant	\$979.975	\$244.994	\$36.043	(\$208.951)	-579.73%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$3,506.467	\$876.617	\$205.578	(\$671.039)	-326.42%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$6,556.329	\$1,639.082	\$535.725	(\$1,103.358)	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
PO ID PO Line Nbr PO Receiver Date Domestic Unit Price PO Receipt Qty Domestic Received Amt Certification Standard					
M7075T6B1.250X07.000					
7075-T6 BART 1.25" X 7.000" ORDER DEFLECTOR TO 50.00"					
PO Rout Seq ID PO Vendor ID	VC-ATG001				
PO37661 4 9/26/2017 8:31:00 AM \$37.6913 22.0000 \$829.209	91.6520		8/28/2017	16.6673	\$868.035
PO37661 4 9/14/2017 10:08:00 AM \$37.6913 4.0000 \$150.765				m138609	
				Total Matl Amts:	\$868.035

Invoice Rout Seq ID		Invoice Vendor ID	VC-ATG001		
Invoice ID	Invoice Line Nbr	Invoice Date	Invoice Unit Price	Invoice Qty	Invoice Amt
913856	1	9/14/2017 4:11:30 PM	37.691325	4.0000	\$150.765

Work Center HAAS 1

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
kiro01		8/31/2017										
110			0.00	0.00	3.55	3.55	1.00	\$0.000	\$66.781	\$194.838	\$0.000	\$261.620
		9/1/2017										
110			0.00	0.00	0.01	0.01	1.00	\$0.000	\$0.094	\$0.274	\$0.000	\$0.368
110			0.00	0.00	6.65	6.65	1.00	\$0.000	\$124.999	\$364.692	\$0.000	\$489.692
110			0.00	0.00	3.33	3.33	1.00	\$0.000	\$62.666	\$182.832	\$0.000	\$245.498
LARO02		8/27/2017										
110			0.00	0.00	7.77	7.77	1.00	\$0.000	\$146.117	\$426.305	\$0.000	\$572.423

Thursday, September 28, 2017 10:47:12 A

Work Order Summary

Page 1 of 2

110		2.24	2.24	0.00	0.00	1.00	\$42.059	\$0.000	\$122.710	\$0.000	\$164.770
	8/28/2017										
110		0.00	0.00	11.89	11.89	1.00	\$0.000	\$223.459	\$651.953	\$0.000	\$875.411
	8/31/2017										
110		0.00	0.00	4.69	4.69	1.00	\$0.000	\$88.183	\$257.279	\$0.000	\$345.463
per01											
	8/29/2017										
110		0.00	0.00	11.84	11.84	1.00	\$0.000	\$222.660	\$649.622	\$0.000	\$872.281
	8/30/2017										
110		0.00	0.00	11.96	11.96	1.00	\$0.000	\$224.833	\$655.962	\$0.000	\$880.795
	Total:	2.24	2.24	61.69	61.69	10.00	\$42.059	\$1,159.793	\$3,506.467	\$0.000	\$4,708.320

Sept. 7

Work Order ID 165122

165122

Page 1

Thursday, August 17, 2017 10:51:55 AM

Item ID: 646.9810

Accept

Revision ID:

Item Name: Deflector

Start Date: 8/25/2017

Start Qty: 22.00

22

Cust Item ID:

Required Date: 9/8/2017

Req'd Qty: 22.00

22

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #
Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.9800

A

2.78

110

110

HAAS I

HAAS CNC VERTICAL MACHINING #1

Memo

14.94

HAAS CNC vertical machine #1

Billet size: 1.250" X 7.000" X 50.000"

1-Machine per folio FB162

DWG REV: A

FOLIO REV: N/C

2- deburr and break all sharp edges

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.22

Quality Control

DAS
39
9-89

17-04-30

Work Order ID 165122

Thursday, August 17, 2017 10:51:55 AM

165122

Page 2

Item ID: 646.9810

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Deflector

Start Date: 8/25/2017 Start Qty: 22.00

22

Cust Item ID:

Required Date: 9/8/2017 Req'd Qty: 22.00

22

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.44

Quality Control

26 *[Signature]*
17/08/03

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

Issue P/O to ATG :

37661

3,960.00

Outsource process - Anodize

AS PER MPP-172 SECTION 2.1,
HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2
AS PER MPP-172 SECTION 4.2,
PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N

Certification of Conformity is required

DAN
15
26 9-80 *[Signature]*

SEP 05 2017

Work Order ID 165122

Thursday, August 17, 2017 10:51:55 AM

165122

Page 3

Item ID: 646.9810

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Deflector

Start Date: 8/25/2017

Start Qty: 22.00

22

Cust Item ID:

Required Date: 9/8/2017

Req'd Qty: 22.00

22

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.44

Packaging

4 SEP 15 2017

22 x SP A-9-27.

155

QC5- Inspect part completeness to step on W/O

0.00

155

QC

Memo

0.44

Quality Control

22

UAS
38
9-89

SEP 28 2017

2-4 mils thickness primer

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

0.22

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

Work Order ID 165122

Thursday, August 17, 2017 10:51:55 AM

165122

Page 4

Item ID: 646.9810

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Deflector

Stop

NS2

Start Date: 8/25/2017 Start Qty: 22.00

22

Cust Item ID:

Required Date: 9/8/2017 Req'd Qty: 22.00

22

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

2.20

Quality Control

Picklist Print

Page 1

Thursday, August 17, 2017 10:51:55 AM

Work Order ID: 165122

165122

Parent Item: 646.9810

646.9810

Parent Item Name: Deflector

Start Date: 8/25/2017

Required Date: 9/8/2017

Start Qty: 22.00

Required Qty: 22.00

Comments: IPP REV:A NEW ISSUE 13/04/01 JFS VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M7075T6B1.250X07.00

Purchased

No

110

f

16.6673

4.166

91.652

0

M7075T6B1 250X07 000

**

7075-T6 BAR 1.25" X 7.000" ORDER PRE CUT TO 50.00"

Location

Loc Qty

Loc Code

MAT007

16.6673

m136248

16.6673

ORDER PRE CUT TO 50.00"

17.000000

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03828

SHEET 1 OF 8

DWG NO. 646.9800

REV: NC

PREPARED BY:

B. PETERS

DATE: 03/19/13

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: DEFLECTOR

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

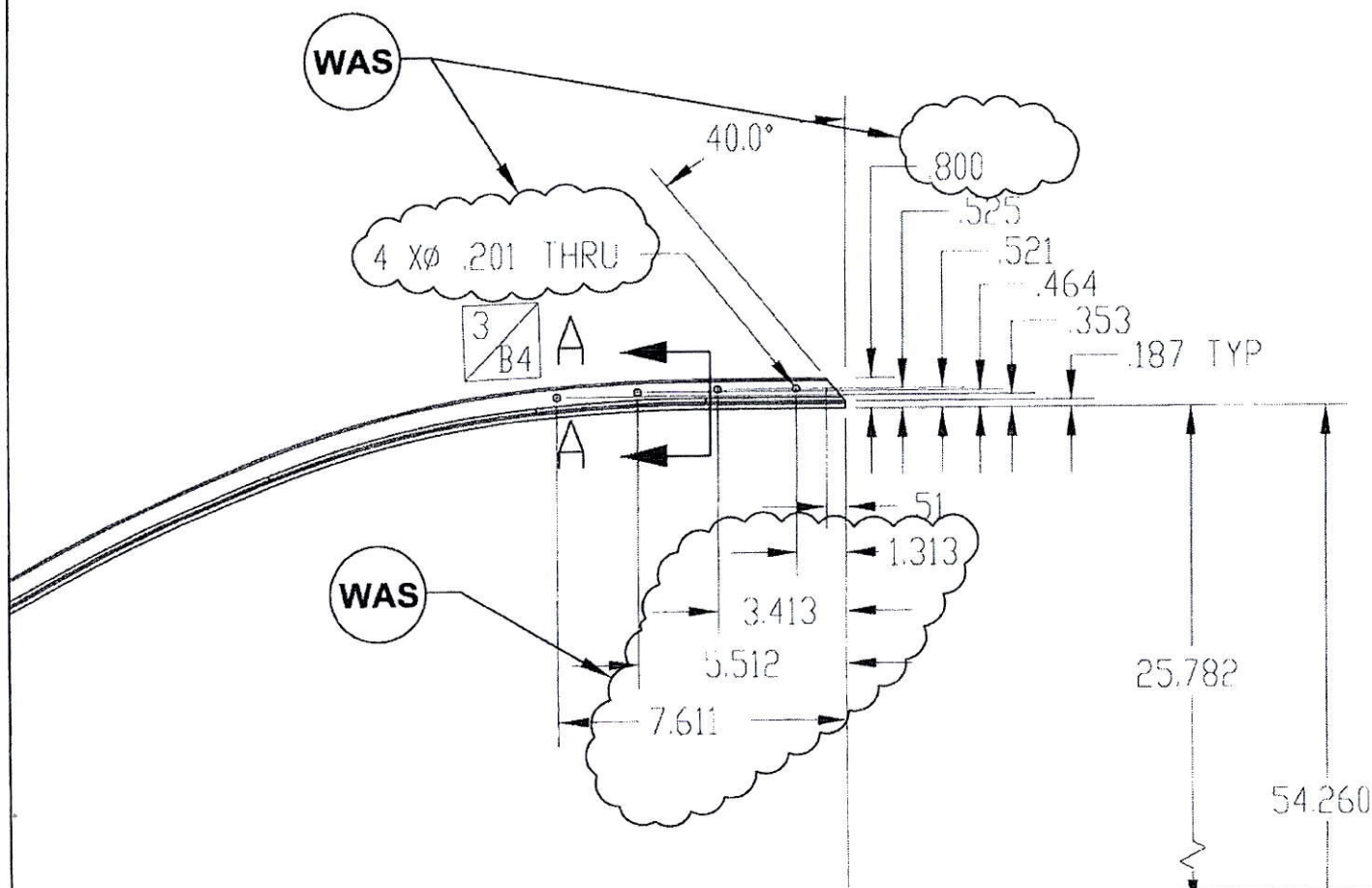
TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED CORNER RADIUS, TOLERANCES, AND ADDED INSPECTION DIMENSIONS.

ECR:

D-13-029

SHEET 1, ZONE A5-A6 & B5-B6 WAS:



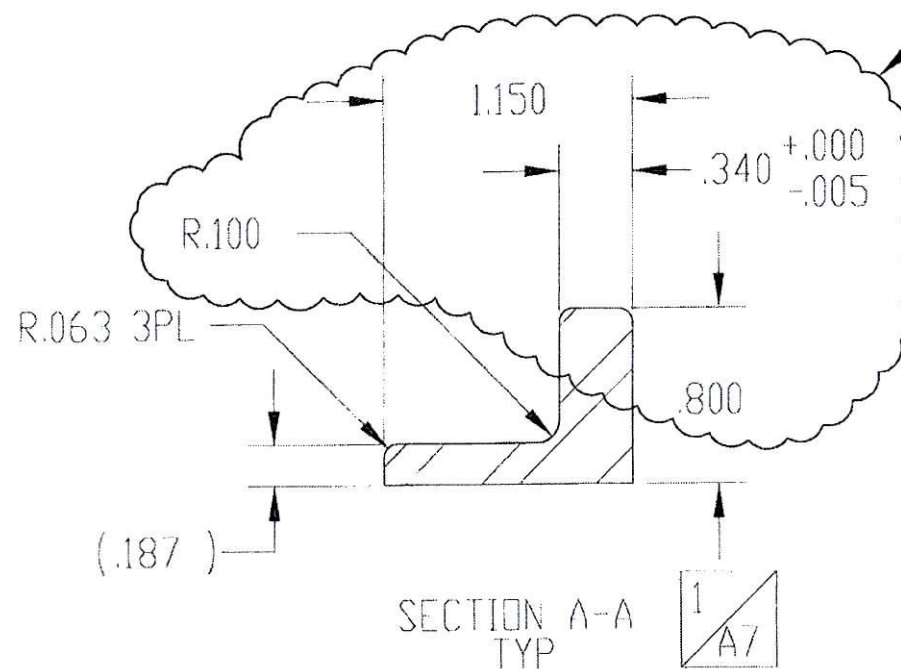
12.512.2
LM 17/8/16

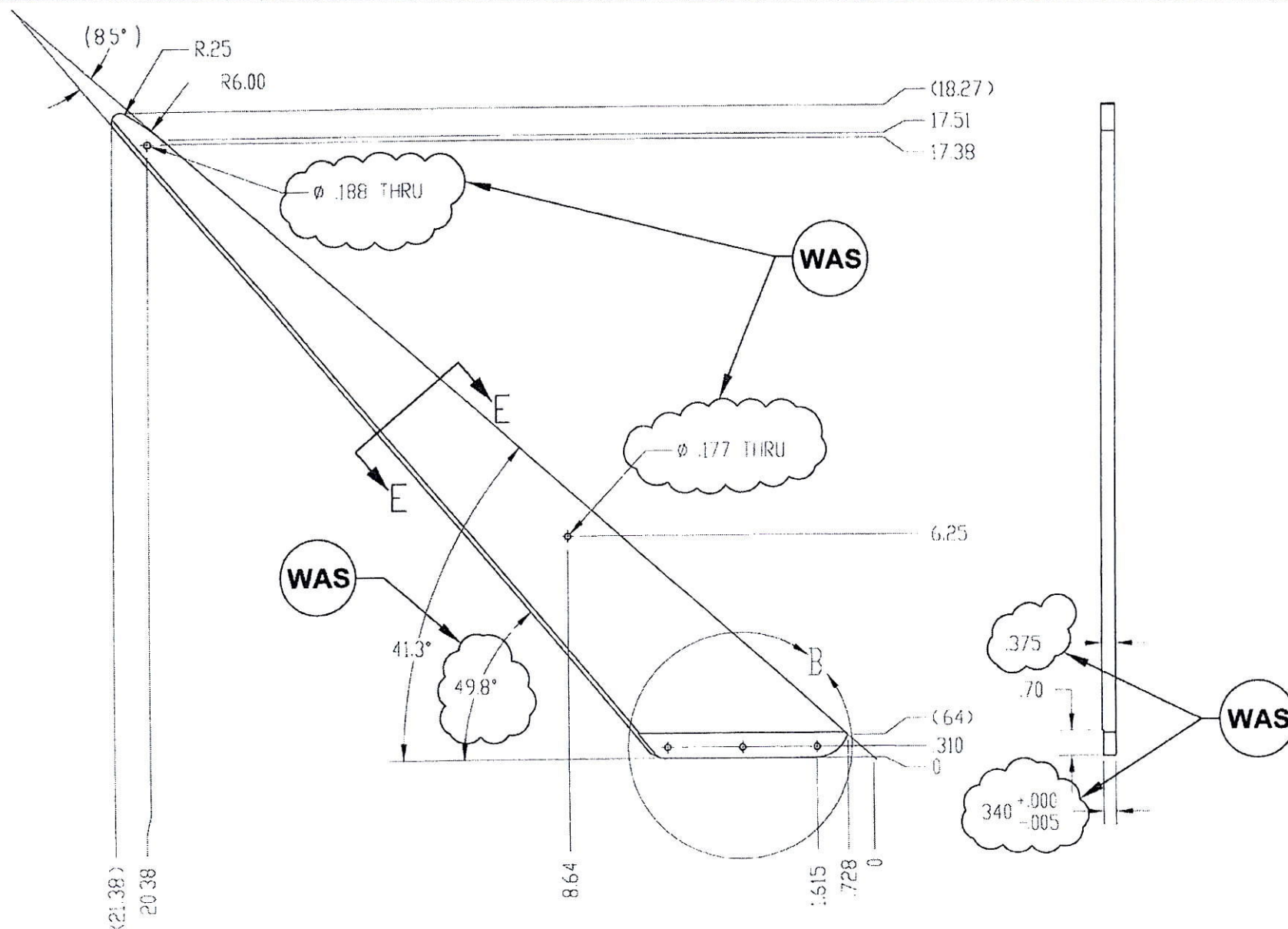
DOCUMENTS EFFECTED:

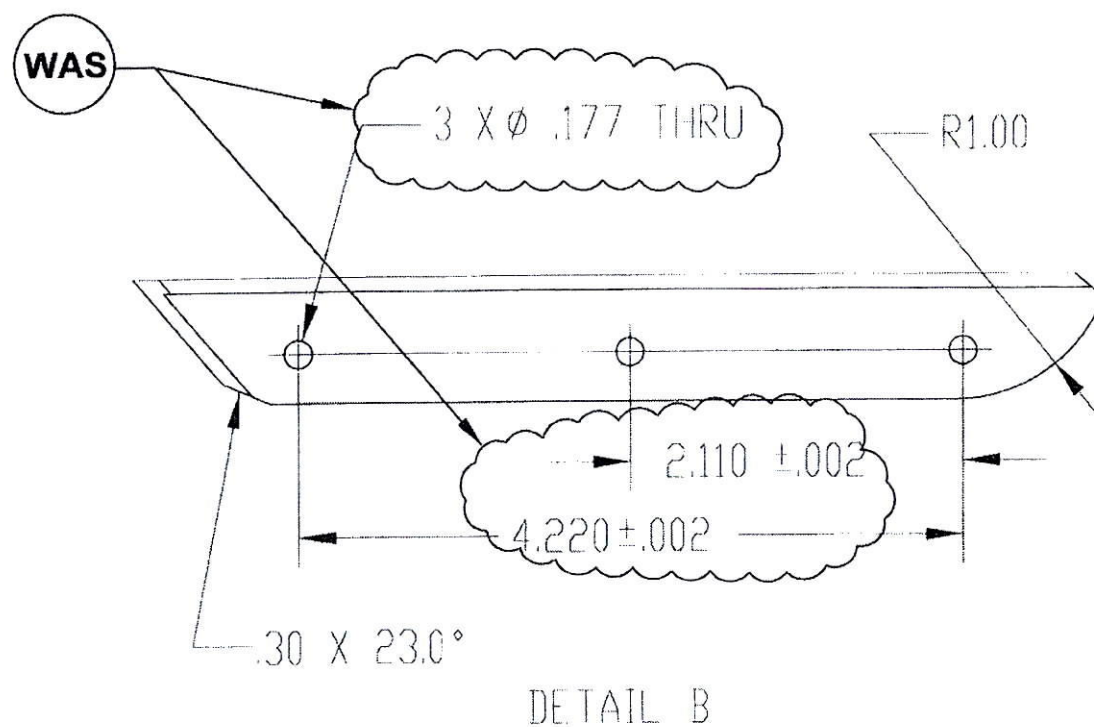
☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM

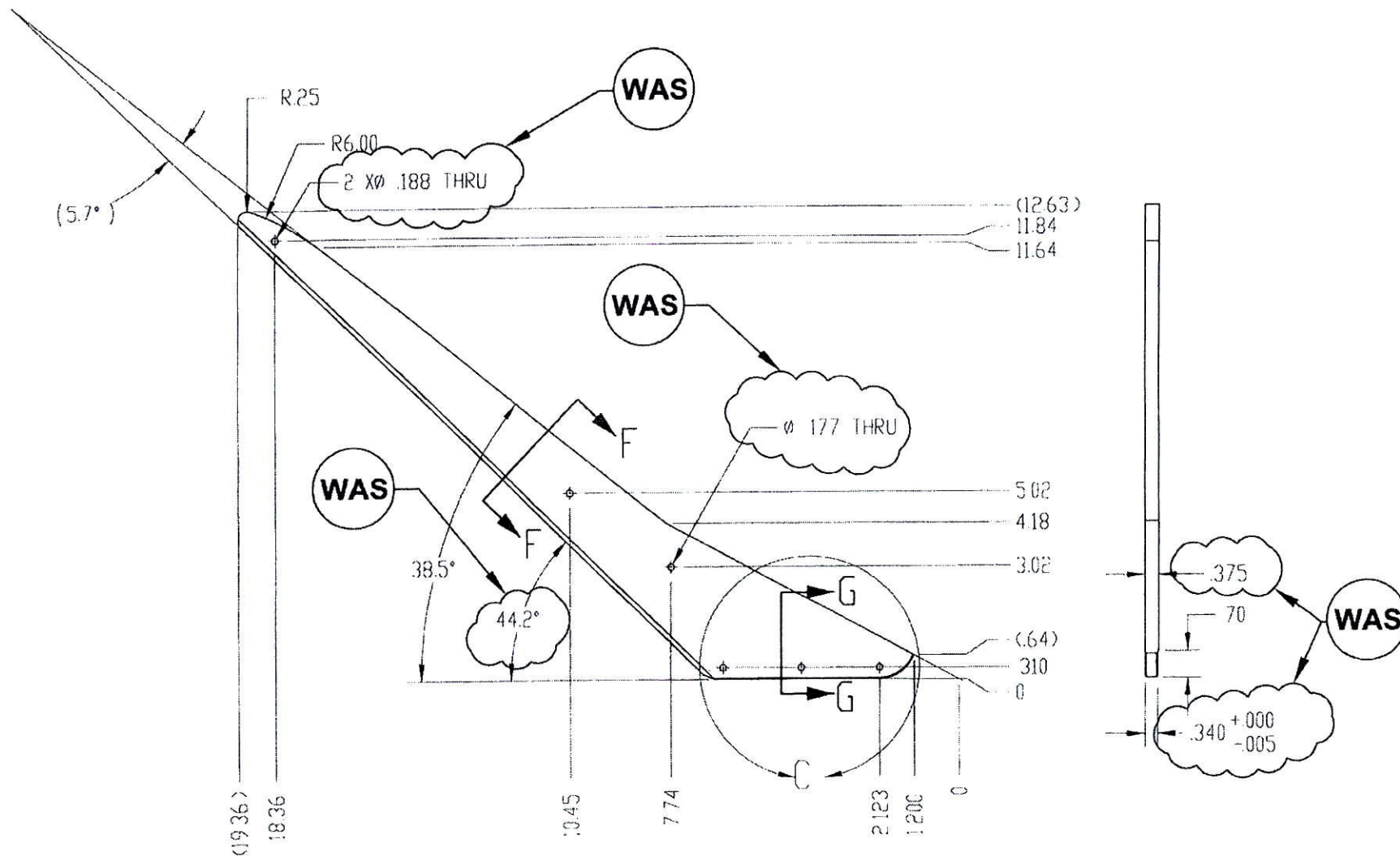
CHANGE CATEGORY
☐ MAJOR ☒ MINOR

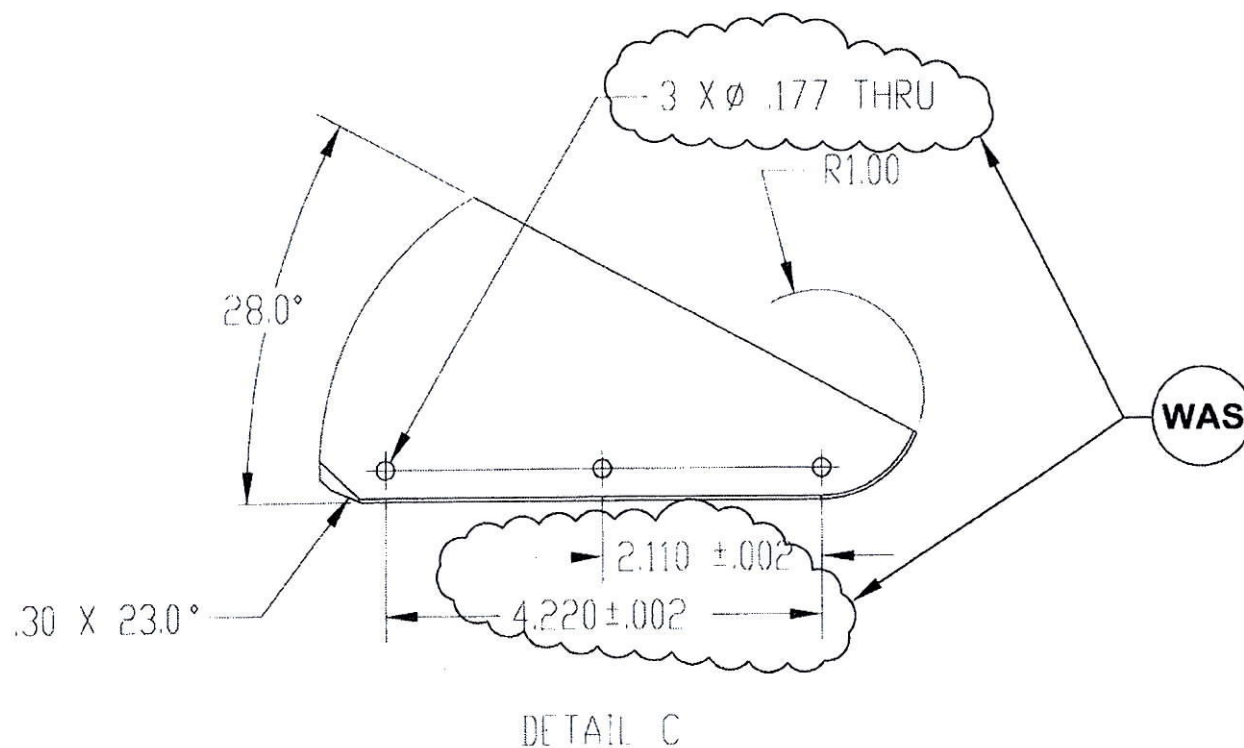
DER REVIEW REQUIRED
☐ YES ☒ NO

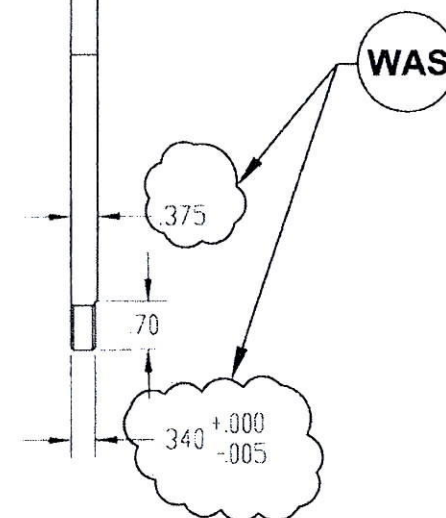
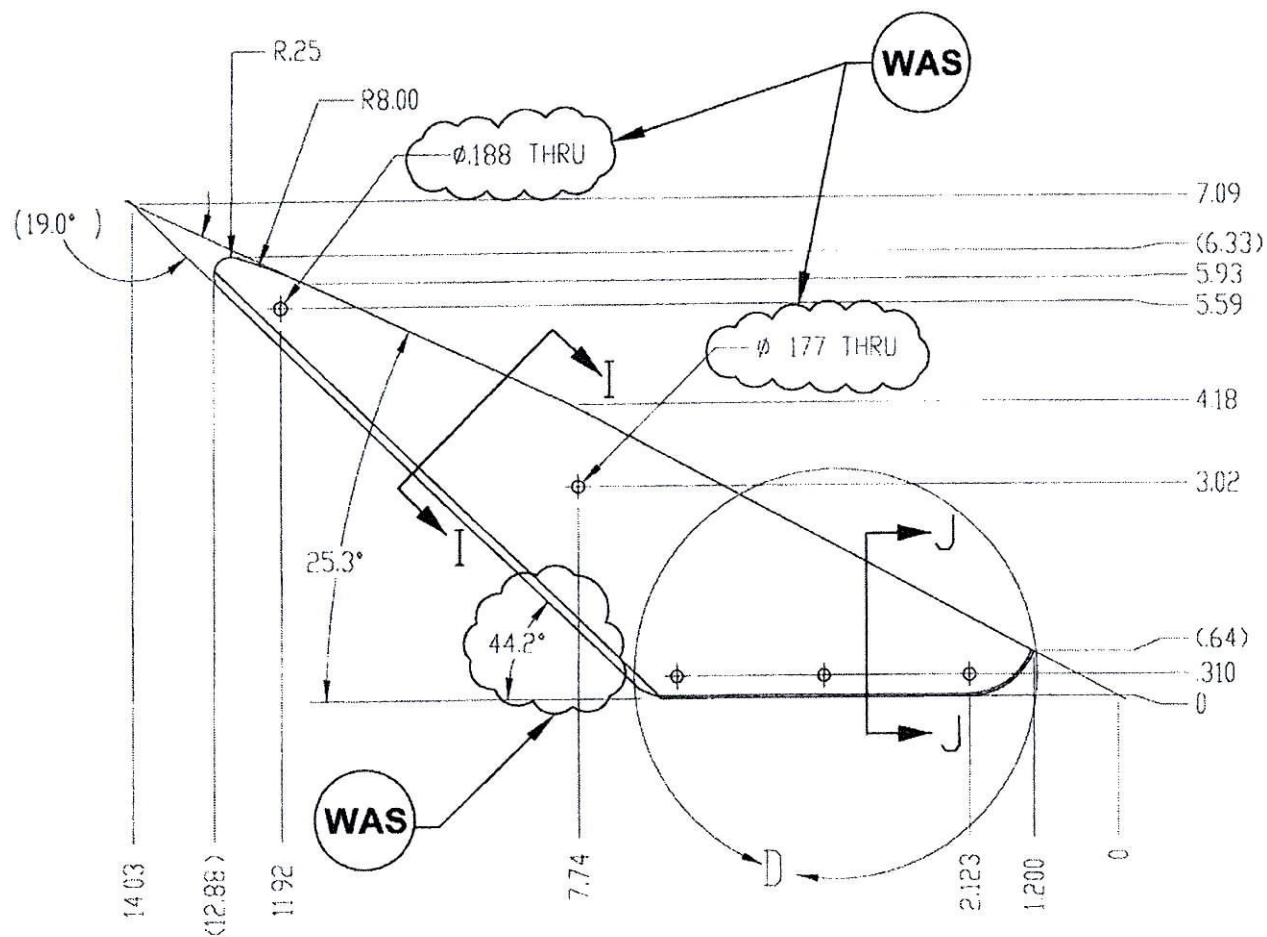
SHEET 3, ZONE A4 & A5 WAS:**WAS**

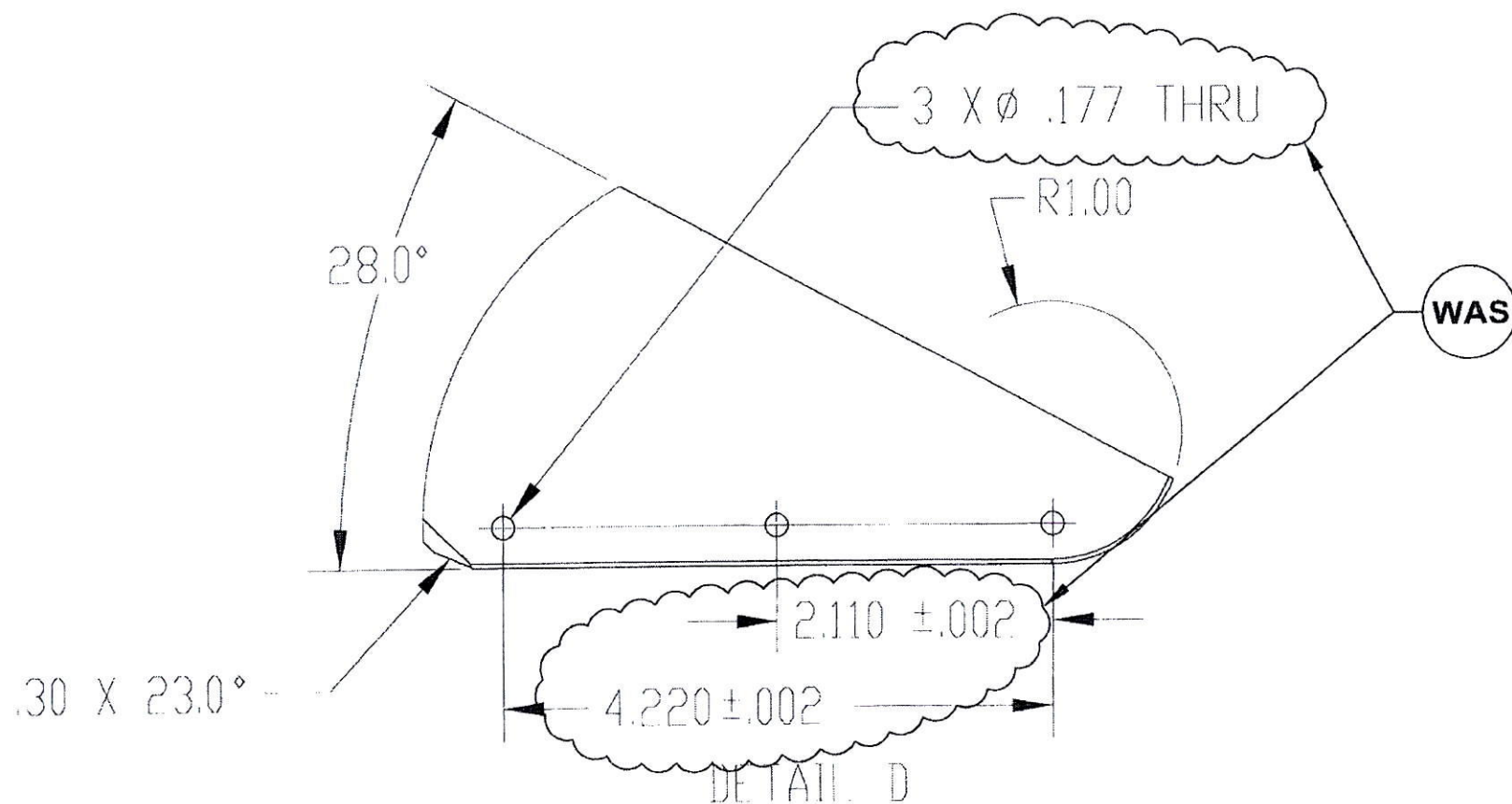
SHEET 4, WAS:

SHEET 4, ZONE C7 & C8 WAS:

SHEET 5, WAS:

SHEET 5, ZONE C8, D7, & D8 WAS:

SHEET 6, WAS:

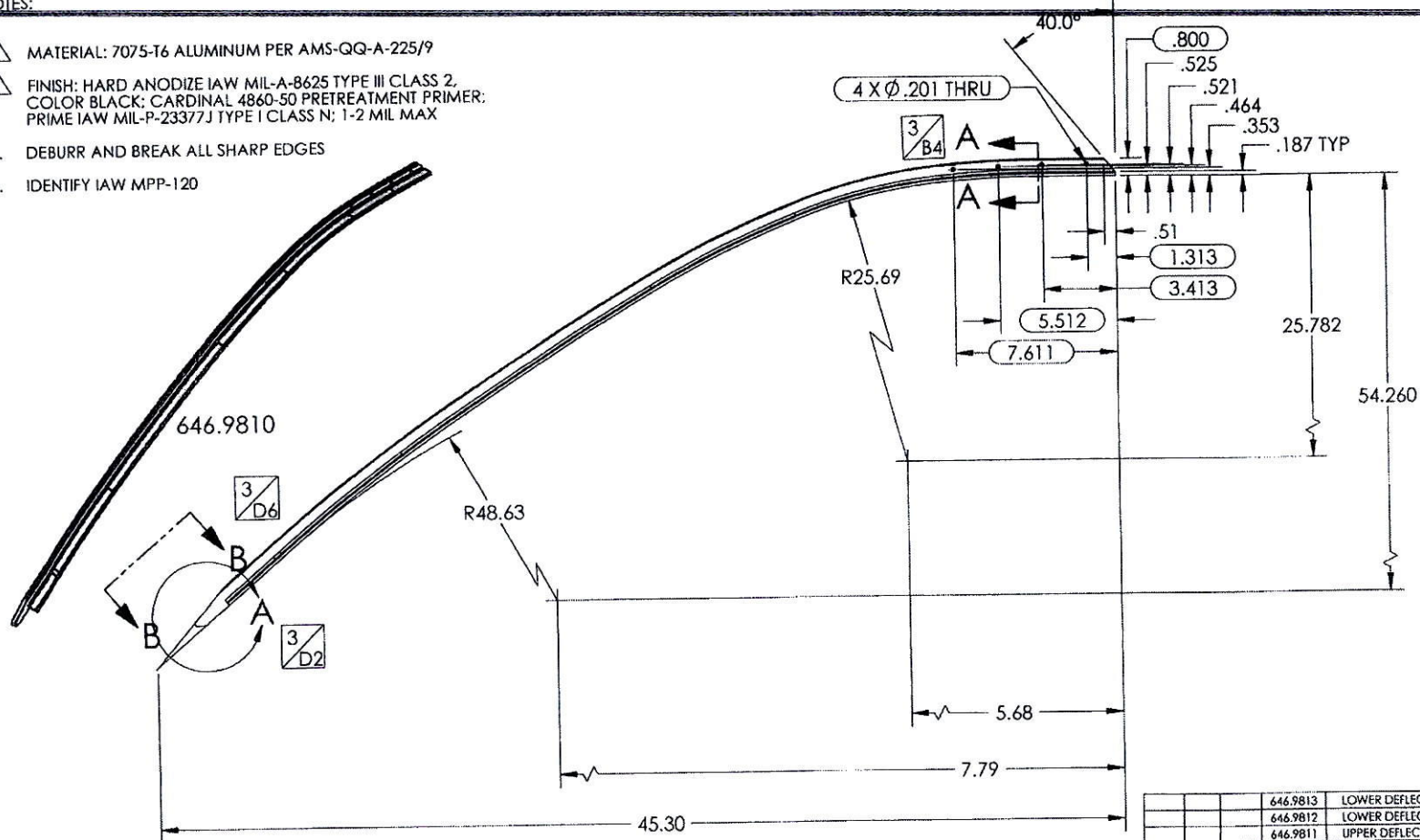
SHEET 6, ZONE C6 & D6 WAS:

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NOTES:

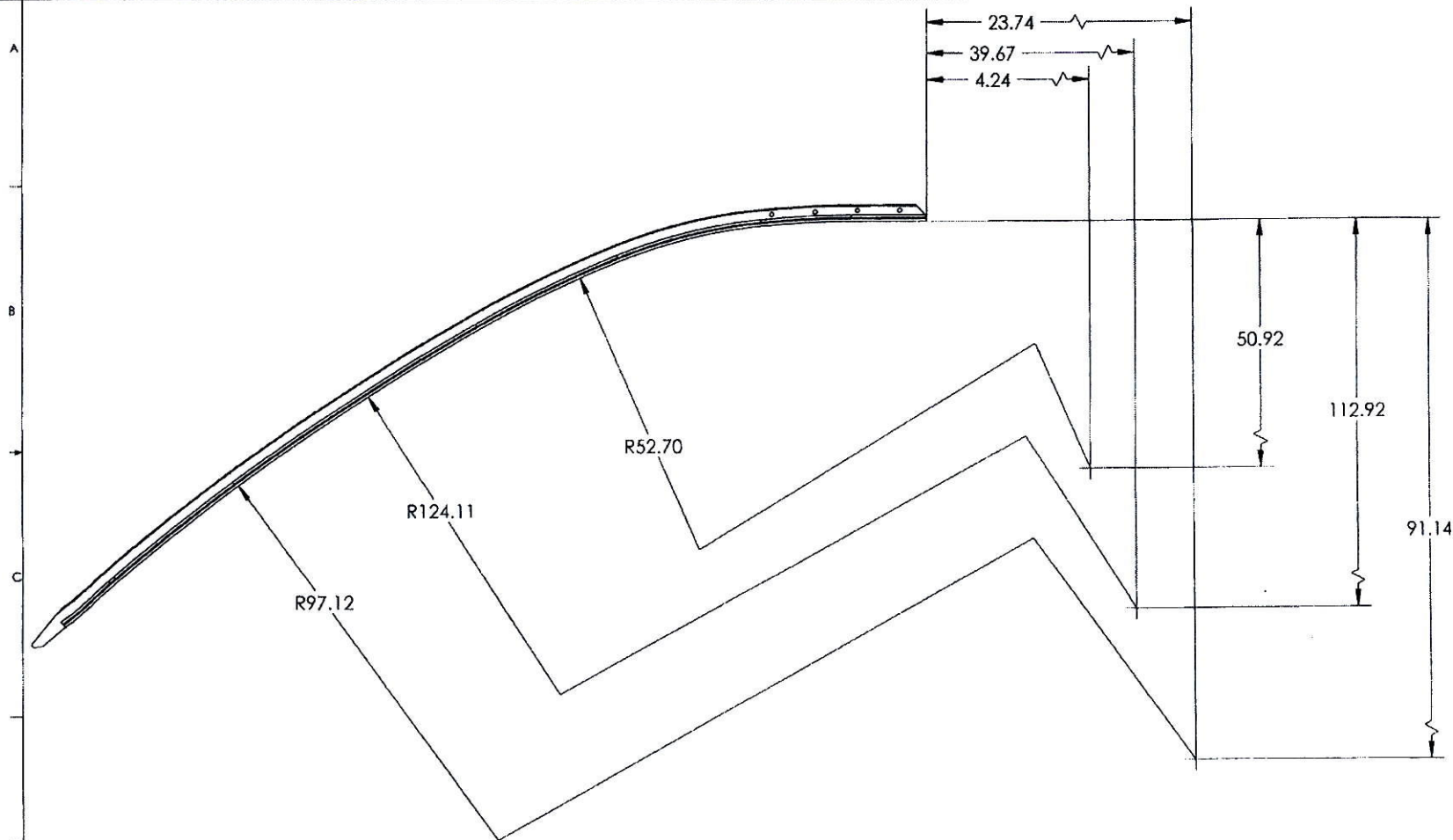
- 1 MATERIAL: 7075-T6 ALUMINUM PER AMS-QQ-A-225/9
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER; PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

REV.	DESCRIPTION	DATE	APPROVED
1/UC	INITIAL RELEASE	04/23/07	P. BRAVO
A	INCORPORATED ECH10078	03/19/13	P. BRAVO



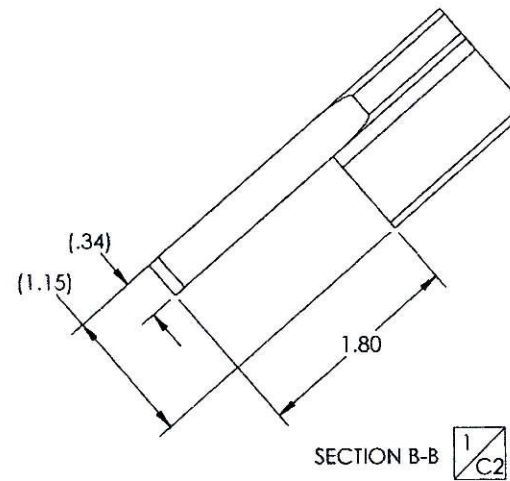
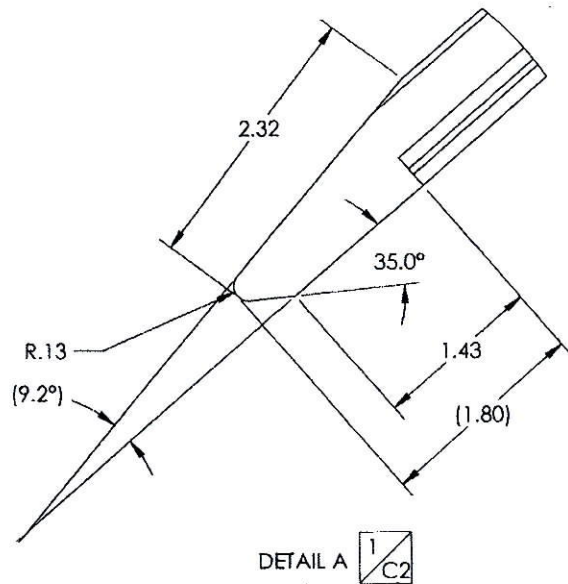
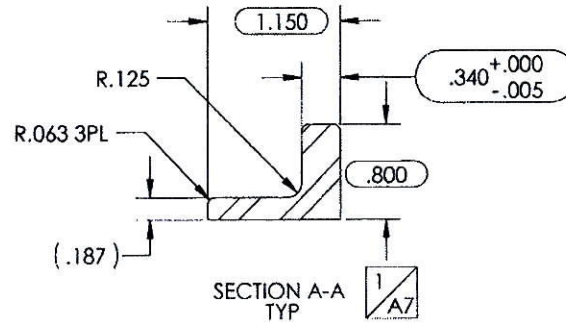
QTY	646.9813	LOWER DEFLECTOR LOW	△	△
QTY	646.9812	LOWER DEFLECTOR HIGH	△	△
QTY	646.9811	UPPER DEFLECTOR	△	△
QTY	646.9810	DEFLECTOR	△	△
FIND #	PART NO.	DESCRIPTION	MATL	SPEC
PARTS LIST				
ORIGINAL DATE: 04-23-07				
DRAWN BY: J. JACKSON				
CHECKED BY: P. BRAVO				
DRAWING APPROVAL: P. BRAVO				
DATE: 04-23-07				
CONTRACT: 102				
UNLESS OTHERWISE SPECIFIED				
DIMENSIONS ARE IN INCHES				
TOLERANCES ARE:				
1 PLACE DECIMALS: ±.02				
2 PLACE DECIMALS: ±.01				
3 PLACE DECIMALS: ±.005				
ANGLE: 1° ± 5'				
APICAL INDUSTRIES				
2608 TEMPLE HEIGHTS DR.				
OCEANSIDE, CA 92056-3512 (760)724-5300				
DEFLECTOR				
REV	QTY	DATE	BY	REV
B	07M26	04-23-07	P. BRAVO	A
SCALE: NONE				
SHEET 1 OF 6				

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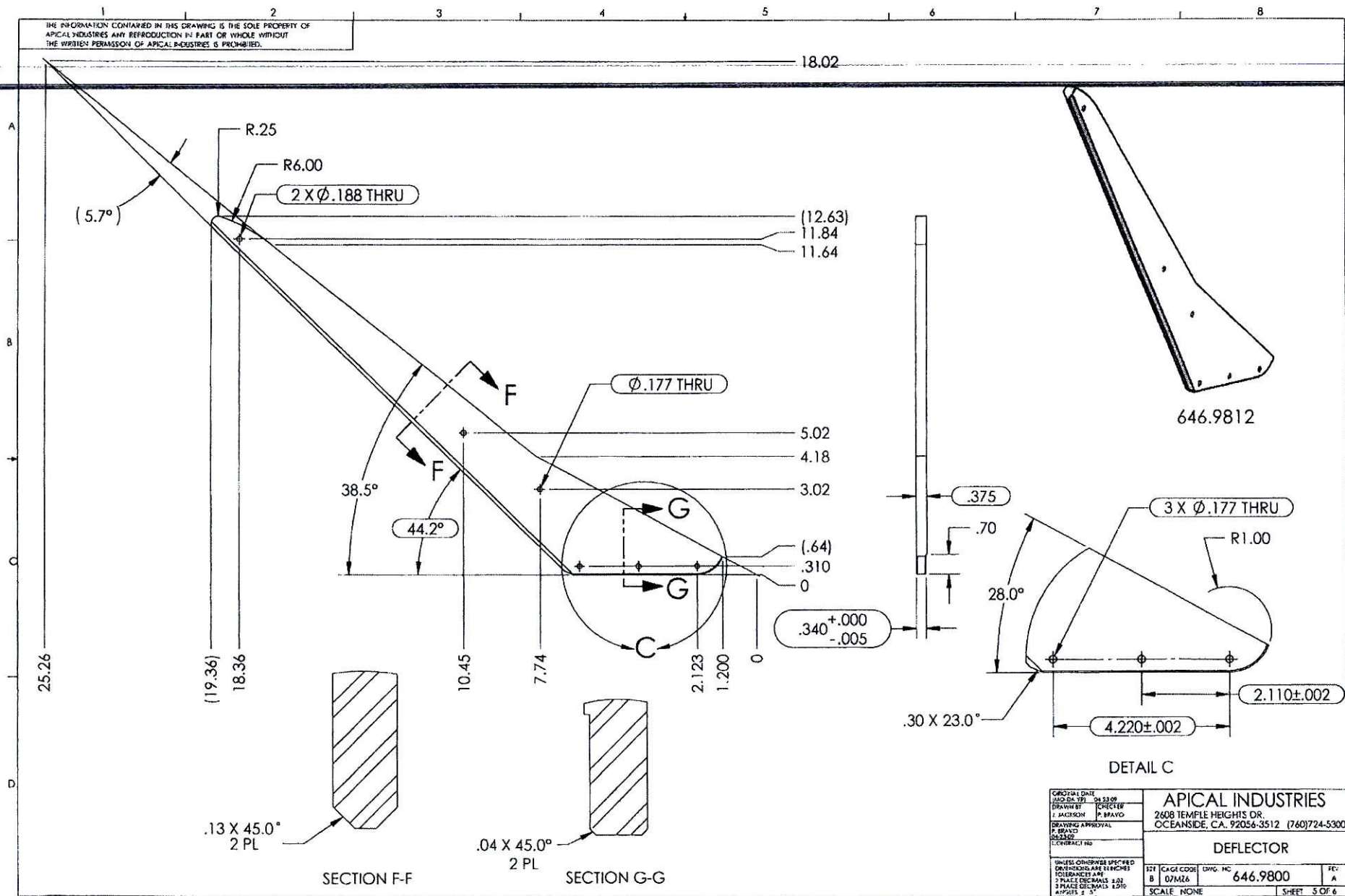
ORIGINAL DATE (DD-MM-YY) 04-20-07		APICAL INDUSTRIES	
DRAWN BY: J. JACKSON		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. BAYO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BAYO		DEFLECTOR	
CONTRACT NO.		646.9800	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.02 3 PLACE DECIMALS ±.010 ANGLES ±.2°		SEE CAGE CODE B D7M126	REV. A
SCALE NONE		SHEET 2 OF 6	

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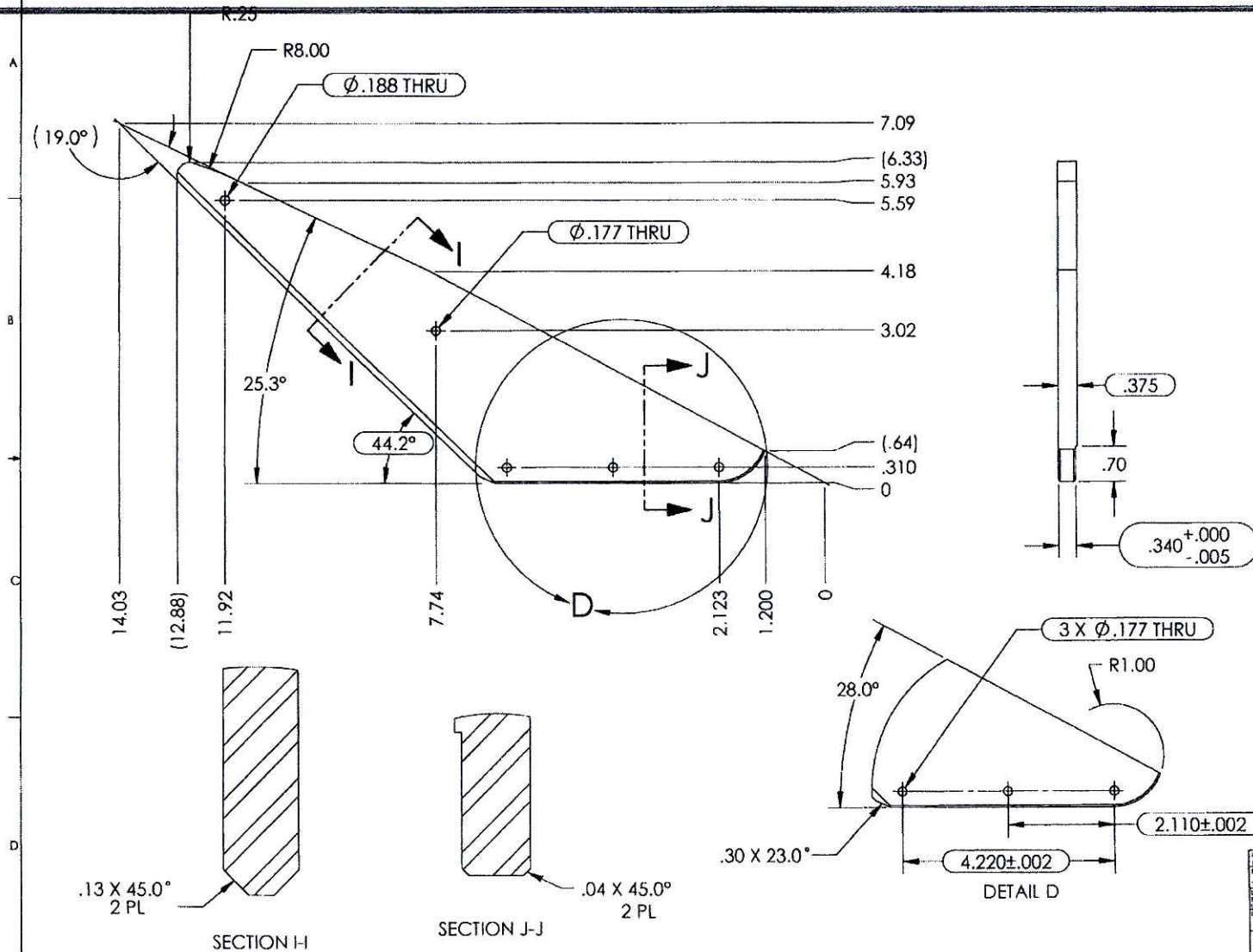
ORIGINAL DATE 06/04/88		APICAL INDUSTRIES	
DRAWN BY J. JACKSON		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. BRAY		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		DEFLECTOR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.02 3 PLACE DECIMALS ±.010 ANGLES ±.5°		REV. CODE	DATE
		B 07/08/86	646.9800
		SCALE: NONE	SHEET 3 OF 4

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ORIGINAL DATE 1/10/84 DRAWN BY J. JACKSON CHECKED BY P. BRAYO DRAWING APPROVAL P. BRAYO IN CHARGE CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. FRACTIONS .005 2. DECIMALS .002 3. HOLE DECIMALS .010 ANGLES .5°		EST. CAGE CODE B 07M26	DWG. NO. 646.9800
SCALE NONE		SHEET 5 OF 6	REV. A

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ORIGINAL DATE 1-20-24-19 01-20-24		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY J. JACKSON		CHECKED BY P. BRAYO	
DRAWING APPROVAL P. BRAYO		SCALE: NONE	
LATEST CHANGES (PAGES) DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .001 3 PLACE DECIMALS .0005 ANGLES: 1/2°		SHEET CODE: 07/24/24 DATE: 07/24/24 SCALE: NONE SHEET 6 OF 6	
DEFLECTOR		646.9800	

DART AEROSPACE LTD		Work Order:	16512.2
Description: Deflector		Part Number:	646.9810
Inspection Dwg: 646.9800 Rev: A			Page 1 of 1

[illegible]

Rev	Date	Change	Revised by	Approved
A	14.06.25	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37661**

Purchase Order Date 9/5/2017

PO Print Date 9/7/2017

Page Number 2 of 5

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Diane Baker

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Qty	Part Number	Description	Unit Price	Total Price
3	165190	647.0310 Channel	16.00	\$11.10
		Yes		
		9/12/2017		

Hard Anodize Color Black. Per IAW MIL-A-8625 Type III Class 2 as per MPP-172 Section 4.2
Prime as Per IAW MIL-P-23377 J Type I Class N
B165190

Qty	Part Number	Description	Unit Price	Total Price
4	165122	646.9810 Deflector	26.00	\$47.25
		Yes		
		9/12/2017		

Hard anodize IAW MIL-A-8625 Type III Class 2, Color Black
Prime IAW MIL-P-23377J Type I Class N; 1-2 MIL Max
B165122

Line Total:

\$177

Line Total:

\$1,228

Qty	Part Number	Description	Unit Price	Total Price
5	165364	646.3719 Doubler	5.00	\$6.15
		Yes		
		9/12/2017		

Hard Anodize IAW MIL-A-8625 Type III Class 2, Color Black
Prime IAW MIL-P-23377J Type I Class N
B165364

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

9/7/2017



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913908

Date: 26-Sep-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
22 ea	Part: 646.9810 Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 21668	Rev:	Line: 4
PO: PO37661			
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>26/9/17</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>Spry-26</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.